



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RB 92700-10349-041-12-PO
Job Sheet 185618



Part No: RB 92700-10349-041-12-PO **Job Qty:** 3 ea

Part Name: Seal Ring Remover Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/31/18

Job Tracking No:

Due Date: 12/14/18

Created By: Patrick Lussier

Type: Stock

Description:

Note: DWG RB 92700-10349-041 Rev.PA5 PRELIM.IPP Rev. A 18.10.29 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing	3 pcs		12/14/18	0.00	0.00	Purchasing		DEC 28 2018
110	Packaging	3 pcs		12/14/18	0.00	0.00	Packaging2		DEC 28 2018
120	QC	3 pcs		12/14/18	0.00	0.00	QC6		DEC 28 2018
130	Small Fab	3 pcs		12/14/18	0.00	0.30	Small Fab-2		9-89
140	QC	3 pcs		12/14/18	0.00	0.00	QC5		
150	Packaging	3 pcs		12/14/18	0.00	0.00	Packaging3		
160	QC21-SA	3 Ea		12/14/18	0.00	0.00	QC21		DEC 31 2018

Part Op 100 - Issue P/O: 041341 MANUFACTURE RB 92700-10349-041-12 AS PER DWG Supplier: ARROW TECH
Descriptions: MACHINE WORKS -Certificate of conformity is required
130 - Re-identify as required.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RB 92700-10349-041-12P	Seal Ring Remover Assembly	3 (1 ea)	100-Purchasing	5140643

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	RB 92700-10349-041-12P	3	0	0

Part Specifications



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

d not be found.

Plex 10/31/18 8:34 AM dart.Lussier.Patrick

Container No: S140645



Part: RB 92700 - 10349 - 041 - 12

Job No: 185618

Serial No/Batch: S140645

Revision: A

Inspector:

Exp Date:

Instructions:

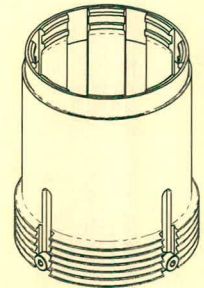
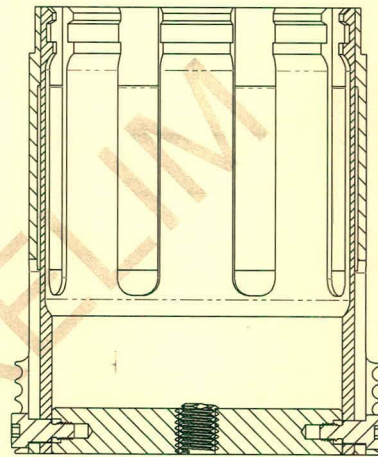
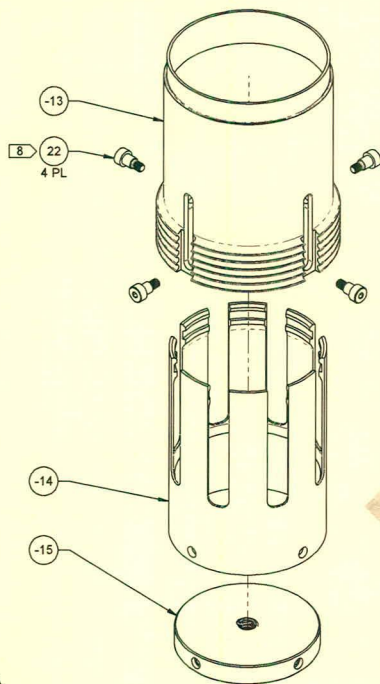
Date: 12/29/18

DEC 3 1900
DEC 3 1900

07
08

DEC 3 1900

ITEM #	QTY	PART #	PART TITLE
-13	1	RB 92700-10349-041-13	SEAL RING REMOVER SLEEVE
-14	1	RB 92700-10349-041-14	SEAL RING REMOVER
-15	1	RB 92700-10349-041-15	PUCK ASSY
22	4	McMaster#93996A836 OR EQUIV	THREAD LOCKING SHOULDER SCREW 1/4" DIA. x 1/4" LG. SHOULDER x #10-32 THREAD



RB 92700-10349-041-12 SEAL RING REMOVER ASSY

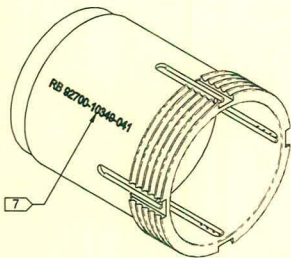
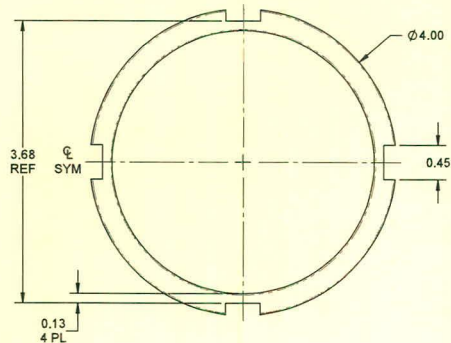
NOTES:

1) MATERIAL: N/A
2) HEAT TREAT: N/A
3) FINISH: N/A

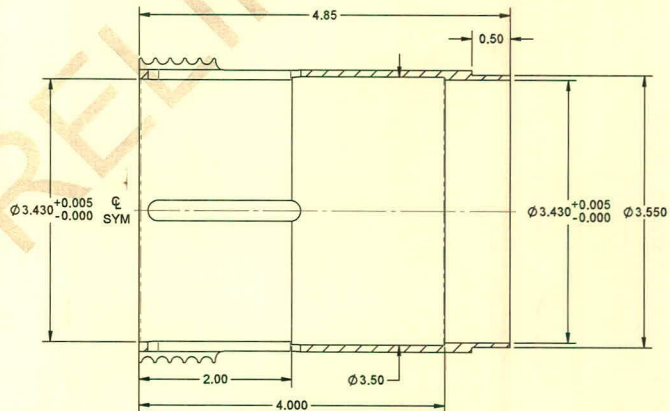
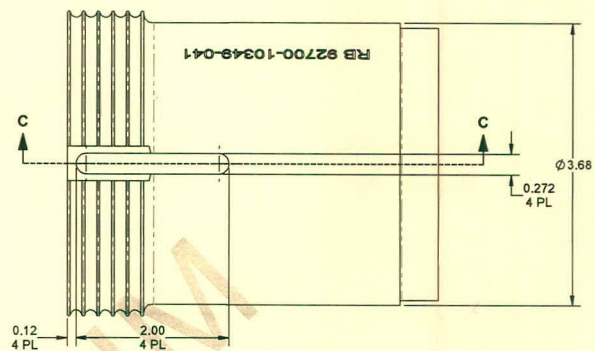
4) TOLERANCES: X.X = $\pm 0.1"$ / $\pm 1"$
X.XX = $\pm 0.01"$ / $\pm 0.5"$
X.XXX = $\pm 0.005"$ / $\pm 0.1"$
X.XXXX = $\pm 0.0005"$ / $\pm 0.05"$
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = $\pm 0.005"$

5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) BREAK SHARP EDGES: N/A
7) IDENTIFICATION: N/A
8) ASSEMBLE AS SHOWN, TORQUE ITEM 21 12-15 IN-LBS

DESIGN	VM	DART AEROSPACE LTD	
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA	
CHECKED		TOOL PART #	REV. A5
MFG. APPR.		RB 92700-10349-041	SHEET 13 OF 17
APPROVED		TITLE	SCALE
DATE 11/10/2018		SEAL REMOVER SET	NTS
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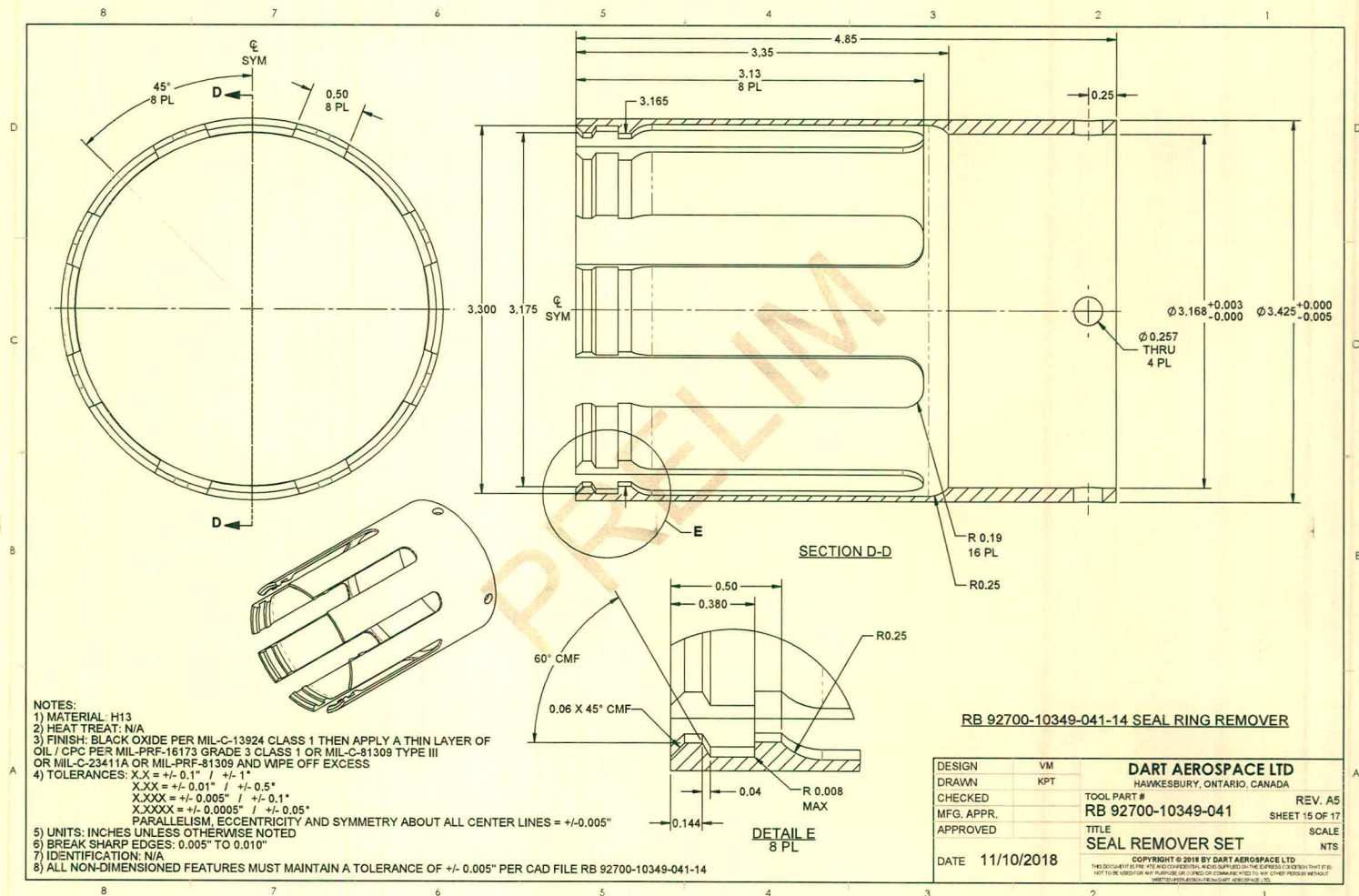
RB 92700-10349-041-13 SEAL RING REMOVER SLEEVE



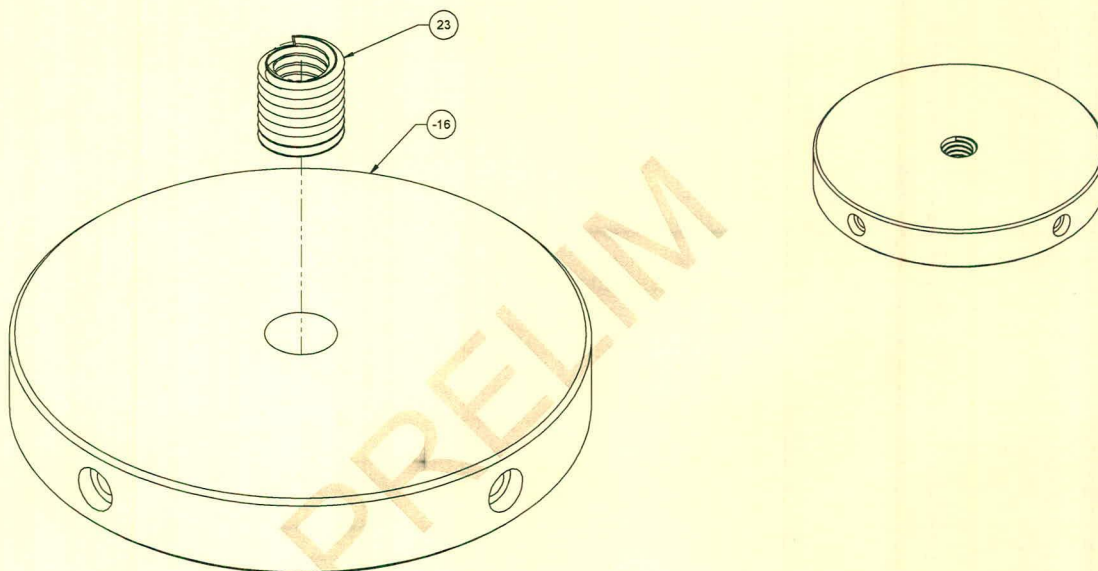
SECTION C-C

- NOTES:
- 1) MATERIAL: 6061-T6 / 7075-T6
 - 2) HEAT TREAT: N/A
 - 3) FINISH: ANODIZE RED PER MIL-A-8625 TYPE 2 CLASS 2
 - 4) TOLERANCES: X.X = ± 0.1 " / ± 0.1 "
X.XX = ± 0.01 " / ± 0.5 "
X.XXX = ± 0.005 " / ± 0.1 "
X.XXXX = ± 0.0005 " / ± 0.05 "
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = ± 0.005 "
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) BREAK SHARP EDGES: 0.005" TO 0.010"
 - 7) IDENTIFICATION: MACHINE ENGRAVE PER CAD MODEL AS SHOWN OR DOT MARK T/N AS SHOWN
 - 8) ALL NON-DIMENSIONED FEATURES MUST MAINTAIN A TOLERANCE OF ± 0.005 " PER CAD FILE RB 92700-10349-041-13

DESIGN	VM	DART AEROSPACE LTD	
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA	
CHECKED		TOOL PART #	REV. A5
MFG. APPR.		RB 92700-10349-041	SHEET 14 OF 17
APPROVED		TITLE	SCALE
		SEAL REMOVER SET	NTS
DATE	11/10/2018	COPYRIGHT © 2018 BY DART AEROSPACE LTD	
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ITEM #	QTY	PART #	PART TITLE
-16	1	RB 92700-10349-041-16	PUCK
23	1	McMaster#91732A214 OR EQUIV	SS HELICAL INSERT 3/8"-16 x .562" LG.



RB 92700-10349-041-15 PUCK ASSY

NOTES:

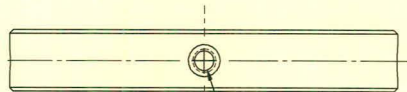
- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = $\pm 0.1"$ / $\pm 1"$

X.XX = $\pm 0.01"$ / $\pm 0.5"$
X.XXX = $\pm 0.005"$ / $\pm 0.1"$
X.XXXX = $\pm 0.0005"$ / $\pm 0.05"$

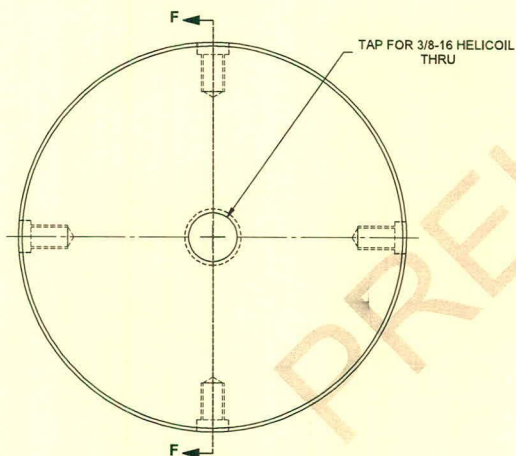
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = $\pm 0.005"$

- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: N/A

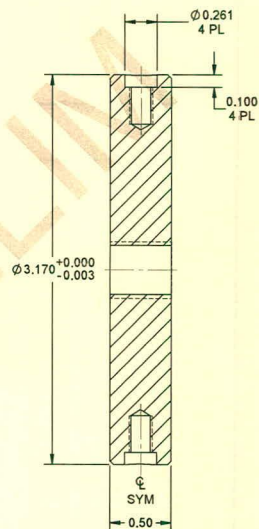
DESIGN	VM	DART AEROSPACE LTD	
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA	
CHECKED		TOOL PART #	REV. A5
MFG. APPR.		RB 92700-10349-041	SHEET 16 OF 17
APPROVED		TITLE	SCALE
		SEAL REMOVER SET	NTS
DATE	11/10/2018	COPYRIGHT © 2018 BY DART AEROSPACE LTD	
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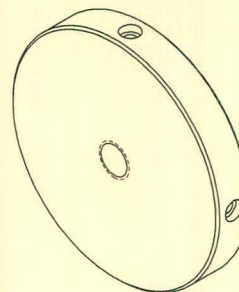
10-32 UNF x 0.40
4 PL



RB 92700-10349-041-16 PUCK



SECTION F-F



NOTES:

1) MATERIAL: 6061-T6 / 7075-T6

2) HEAT TREAT: N/A

3) FINISH: ANODIZE RED PER MIL-A-8625 TYPE 2 CLASS 2

4) TOLERANCES: X.X = +/- 0.1" / +/- 1°

X.XX = +/- 0.01" / +/- 0.5°

X.XXX = +/- 0.005" / +/- 0.1°

X.XXXX = +/- 0.0005" / +/- 0.05°

PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"

5) UNITS: INCHES UNLESS OTHERWISE NOTED

6) BREAK SHARP EDGES: 0.005" TO 0.010"

7) IDENTIFICATION: N/A

DESIGN	VM	DART AEROSPACE LTD	
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA	
CHECKED		TOOL PART #	REV. A5
MFG. APPR.		RB 92700-10349-041	SHEET 17 OF 17
APPROVED		TITLE	SCALE
		SEAL REMOVER SET	NTS
DATE	11/10/2018	COPYRIGHT © 2018 BY DART AEROSPACE LTD	
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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041341**

Supplier: ARR002-VU
Arrow Tech Machine Works
29751 E. Enid Road,
Unit C
Eugene, OR 97402 USA
Phone: 541-780-6938
Fax: 458-215-4938

PO No: PO041341
PO Date: 10/12/18
Due Date: 12/21/18
Purchase Order Revision:
Revision Date:
Ship-To Contact: Belanger, Natasha
Phone:
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Ship To:

Items

Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
4	185585	RB 92700-10308-041-4P			Input Module Seal Installer Assembly REV A	Firmed	-	12/21/18	3 Ea	0 Ea	3 Ea	\$1,856.00/Ea	\$5,568.00
Line Item Note SIOP													
10	185621	RB 92700-10307-041P			TR Nut Wrench REV A	Firmed	-	12/21/18	1 Ea	0 Ea	1 Ea	\$1,694.00/Ea	\$3,388.00
Line Item Note SIOP													
11	185622	RB 92700-10301-041P			Pitch Beam Puller REV A	Firmed	-	12/21/18	3 Ea	0 Ea	3 Ea	\$0.01/Ea	\$0.03
Line Item Note SIOP													
12	185623	RB 92700-10329-041-4P			Removal Tool Assembly REV A	Firmed	-	12/21/18	3 Ea	0 Ea	3 Ea	\$1,543.00/Ea	\$4,629.00
Line Item Note SIOP													
16	185663	RB 92700-10334-042P			Engine Lifting Sling REV A	Firmed	-	12/21/18	3 Ea	0 Ea	3 Ea	\$0.01/Ea	\$0.03
Line Item Note SIOP													
17	185665	RB 92700-10355-101P			Torque Adapter REV A	Firmed	-	12/21/18	3 Ea	0 Ea	3 Ea	\$1,448.00/Ea	\$4,344.00
Line Item Note SIOP													



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO041341

Items

Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
18	185616	RB 92700-10349-041-5P			Handle Assembly REV A5	Firmed	-	12/21/18	3 Ea	0 Ea	3 Ea	\$998.00/Ea	\$2,994.00
Line Item Note SUB ASSY FOR TOP LEVEL RB 92700-10349-041													
19	185617	RB 92700-10349-041-8P			Seal Case Remover Assembly REV A5	Firmed	-	12/21/18	3 Ea	0 Ea	3 Ea	\$998.00/Ea	\$2,994.00
Line Item Note SUB ASSY FOR TOP LEVEL RB 92700-10349-041													
20	185618	RB 92700-10349-041-12P			Seal Ring Remover Assembly	Firmed	-	12/21/18	3 Ea	0 Ea	3 Ea	\$998.00/Ea	\$2,994.00
Line Item Note SUB ASSY FOR TOP LEVEL RB 92700-10349-041													
												Grand Total:	\$26,911.06

Order Notes

Procurement Quality Clauses

A005 RIGHT OF ENTRY

A008 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION SENT TO DART AEROSPACE)

A012 CHEMICAL AND PHYSICAL TEST REPORTS

A016 PERSONNEL QUALIFICATION

A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)

A026 CERTIFICATION OF MATERIAL CONFORMANCE

A041 QUALITY MANAGEMENT SYSTEM

A042 DART NOTIFICATION BY SUPPLIER

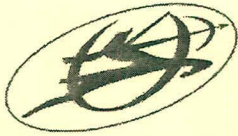
A043 RETENTION OF QUALITY DOCUMENT

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM

A049 SUPPLIER AWARENESS

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 12/21/18 2:18 PM dart.belanger.natasha



**PHGE Machineworks dba
Arrowtech Machineworks**
29751 E Enid Rd. Unit C
Eugene, Oregon 97402
Phone: (541) 780-6938
Fax: (458) 215-4938

Packing Slip

NO. 376

Date: 12/27/2018
PO Ref: 041341 ✓
Ship via: Fedex Priority

Bill To:
Dart Aerospace
1270 Aberdeen St. Hawkesbury, ON
CANADA K6A 1K7

Ship To:
Dart Aerospace
1271 Aberdeen St. Hawkesbury, ON
CANADA K6A 1K8

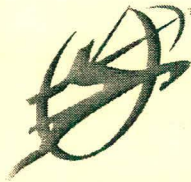
Qty	Item	Part No.
3	HANDLE ASSEMBLY	RB 92700-10349-041-5
3	SEAL CASE REMOVER ASSEMBLY	RB 92700-10349-041-8
3 ✓	SEAL RING REMOVER	RB 92700-10349-041-12 ✓
3 ✓	REMOVAL TOOL ASSEMBLY	RB 92700-10329-041-4 ✓
3	INPUT MODULE SEAL INSTALLER ASSEMBLY	RB 92700-10308-041-4
1	PITCH BEAM PULLER	RB 92700-10301-041
1	TR NUT WRENCH	RB 92700-10307-041

Received by: _____

Packaged by: AM

Checked by: CS

Thank You



ARROW TECH MACHINE WORKS

Certificate of Conformance

Your Purchase Order No: 041341 ✓

Dated: 12/27/2018

Our Order / Job No: 041341-20AWT

Order Qty: 3 ✓

Part Name: RING REMOVER ASSY.

Part Number: RB 92700-10349-041-12 ✓

Lot Size: N/A

Ship Date: 12/27/2018

We certify that these parts shipped to you are of domestic or international manufacture and conform to all requirements of the Purchase Order. These parts have been manufactured and inspected in accordance with all required specifications, instructions and drawings. Any applicable specifications are listed below:

Drawing Number: RB 92700-10349-041-12

Rev: A

Material Size and Type: -13,-16/6061-T6 ALUM. ; -14/H13 STEEL

Material Specifications: ALUM: ASTM B209; STEEL: ASTM A681

Heat Treatment: -13/41.0 HRC

Plating/Finish: RED ANODIZE: MIL-A-8625F TYPE 2 CLASS 2; BLACK OXIDE: QMSI-6.2.2
B.O. REV D

Mercury Contamination: The material used to process this order has not come in contact with mercury or mercury bearing instruments.

Date: 12/27/18

Signed: 

DAS
68
9-89

PHGE Machine Works LLC dba Arrow Tech Machine Works
29751 E. Enid Rd. Unit C Eugene, Oregon 97402
Main: (541) 780-6938 | Fax: (458) 215-4938
www.atechmachineworks.com

